

Work Order ID 68613

Monday, April 18, 2011 2:58:10 PM



Page 1

Item ID: D212-664-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 4/18/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00

Customer:



Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 4-18-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-241	Rev D								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-201

CNC003

CNC004

[Handwritten signature]

[Handwritten signature] 11-5-26
①

110

0.00



Pick Kit

Packaging

Packaging

Memo

0:00

Packaging

[Handwritten signature]

11-5-12

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

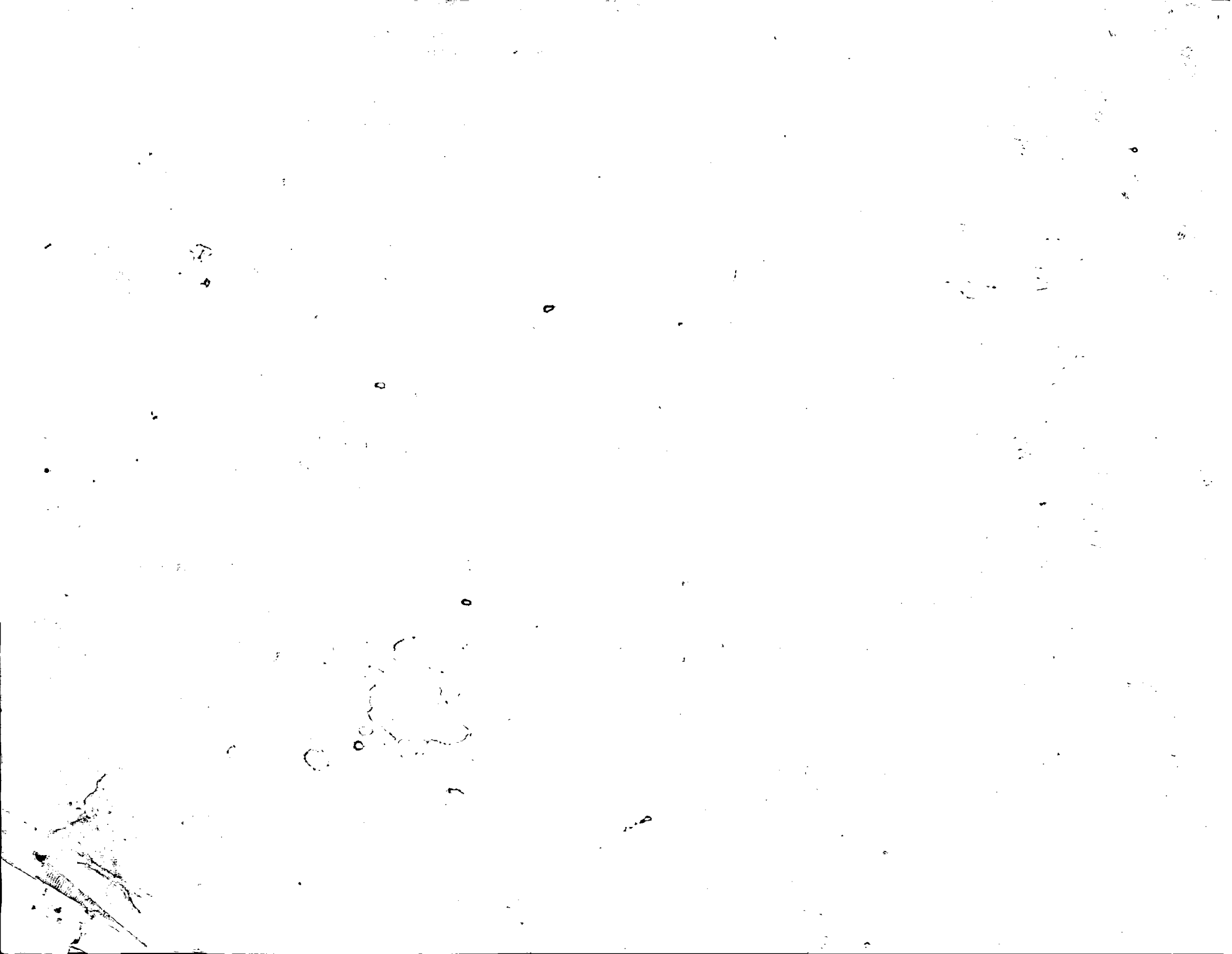
0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-241 using CNC bender program 212-
aft

[Handwritten signature]

11-5-12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-201 PAR #: J.P. Fault Category: x-tubes NCR: Yes No DQA: 11 Date: 11.06.01
 11-632 Resolution: Repair Disposition: Repair QA: N/C Closed: 11/06/01 Date: 11/06/01

NCR: <u>68613</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.05.13	120	TUBE IS BENT HIGH, 24.75" (24.630 (0.45/0.333 OVER NOMINAL) RC: Process	CP 11.05.13 PS/042	Trim cuff 0.13" to 0.1" ON 24.75" SIDE.	11-5-16 11.05.16	CP 11.05.16	CP 11.05.13 PS/042	8 11/05/16

NOTE: Date & initial all entries

Work Order ID 68613

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

11-05-16

140

Crosstubes

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550, DT8551, drill table DT8577 and locate tower holes #8 as per QSI0010.

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

SAD
TW 11-05-16SAD
11-05-16

3

Work Order ID 68613

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Item ID: D212-664-201

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Item Name: Crosstube Aft

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat as within 24 hours of bending and drilling

SAD
11-05-16

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S. W. L. S.
REV-6

14/05/2011

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11.05.10

AUTH

RELEASED

DATE

11.05.10

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Item ID: D212-664-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2
SprayPaint

0.00

Memo

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: _____

Finish Time: _____

11-05-18

PAINT:

Start Time: _____

Finish Time: _____

11-05-19

25 11-05-19

220



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Then, Wrap in plastic bag to protect from scratches

8/11/05/20

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Page 6

Item ID: D212-664-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Crosstubes	0.00							
	Crosstubes								
Crosstubes	Memo	0.00							
	1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe								
	2-Install supports with magnobond as per QSI 015. Adhere for 12 Hrs								
	A/R 6398 Magnobond Batch: <u>116677</u>								
	Expiry Date: <u>11-06</u>								
	3-Install clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.								
240	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

21 11-05-25

Sulostu

①

Work Order ID 68613

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Monday, April 18, 2011 2:58:10 PM

Item ID: D212-664-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/5/26

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 11/5/26

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212-664-201

Rev 4

11/5/30

Work Order ID 68613

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Item ID: D212-664-201

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft

Start Date: 4/18/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

N/A 4/11/05.30

11-05-26

Picklist Print

Monday, April 18, 2011 2:58:17 PM

Page 1

Work Order ID: 68613

Parent Item: D212-664-201

Parent Item Name: Crosstube Aft



Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.02.16 Reformat K/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 07-04-30 As per Rev C JLM
 IPP Rev:H 08-05-22 up date Qty of rubber cushion DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664- 201TRNRevC		Manufactured	No	B68803		110	Each	0.0000	1	1		11-5-12	
Crosstube Turning Detail													
D3595-063-530		Manufactured	No			230	Each	64.0000	2	2		11-05-29	
RUBBER CUSHION													

D2940-1		Manufactured	No			230	Each	17.0000	2	2		11-05-25	
Support													

MS21920-28		Purchased	No			230	Each	90.0000	4	4		11-05-25	
Clamp(per MIL-DTL-8783C)													

Location	Loc Qty	Loc Code
FG	5	
105884	5	
LG050	85	
116839	35	
117344	50	



Picklist Print

Page 2

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Work Order ID: 68613

Parent Item: D212-664-201

Parent Item Name: Crosstube Aft

Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3428-1

Manufactured No

250 Each

15.0000

1


Placard



Handwritten: 1

Location

Loc Qty

Loc Code

ST053

15

66115

3

66961

12

MS21042L6

Purchased

No

250

Each

354.0000

6


Nut



Handwritten: 6

Location

Loc Qty

Loc Code

ST300

354

116373

5

116548

49

117343

300

AN960JD616

NAS1149D0663J

Purchased

No

250

Each

0.0000

18


Washer



Handwritten: 18

AN6-40A

Purchased

No

250

Each

122.0000

4


Bolt



Handwritten: 4

Location

Loc Qty

Loc Code

ST340

80

117366

80

ST343

42

115300

2

115905

20

116549

20

Handwritten: 117366

Monday, April 18, 2011 2:58:17 PM

Shop Packet Print

Page 2

Picklist Print

Page 3

Monday, April 18, 2011 2:58:17 PM

Work Order ID: 68613



Parent Item: D212-664-201



Parent Item Name: Crosstube Aft

Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

AN6-41A

Purchased

No

250

Each

71.0000

2

2



Bolt



M117688

4/15/26

Location

Loc Qty

Loc Code

ST344

71

115316

21

117366

50

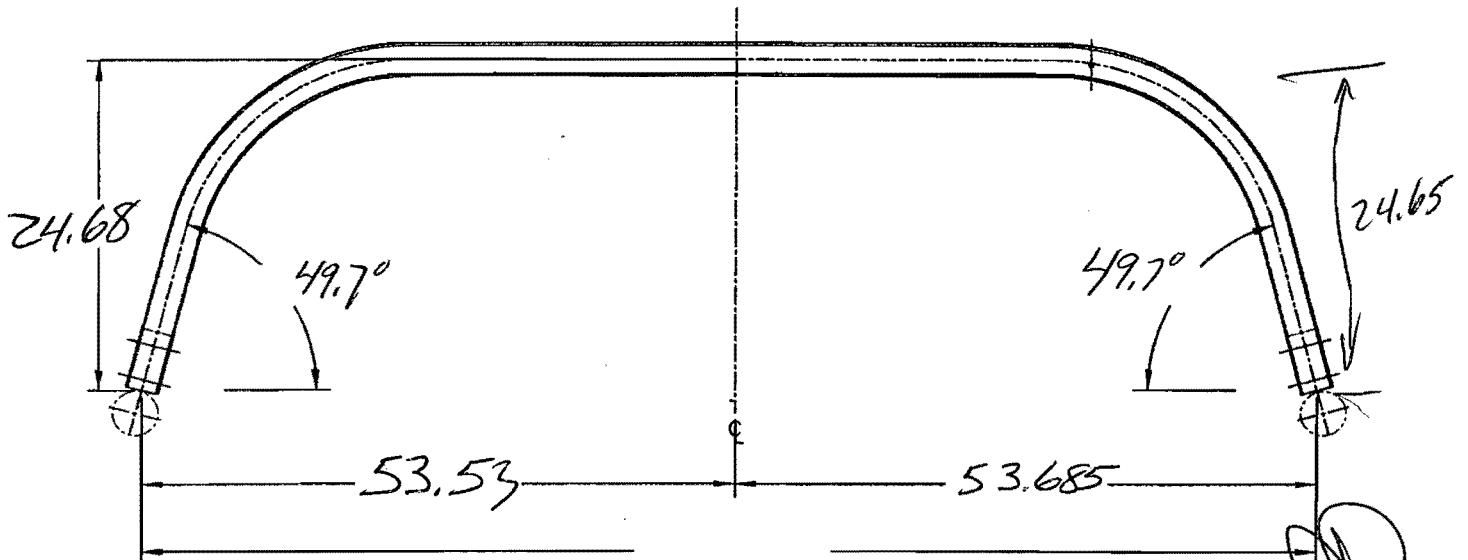
Monday, April 18, 2011 2:58:17 PM

Shop Packet Print

Page 3

DART AEROSPACE LTD		Work Order:	68613
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



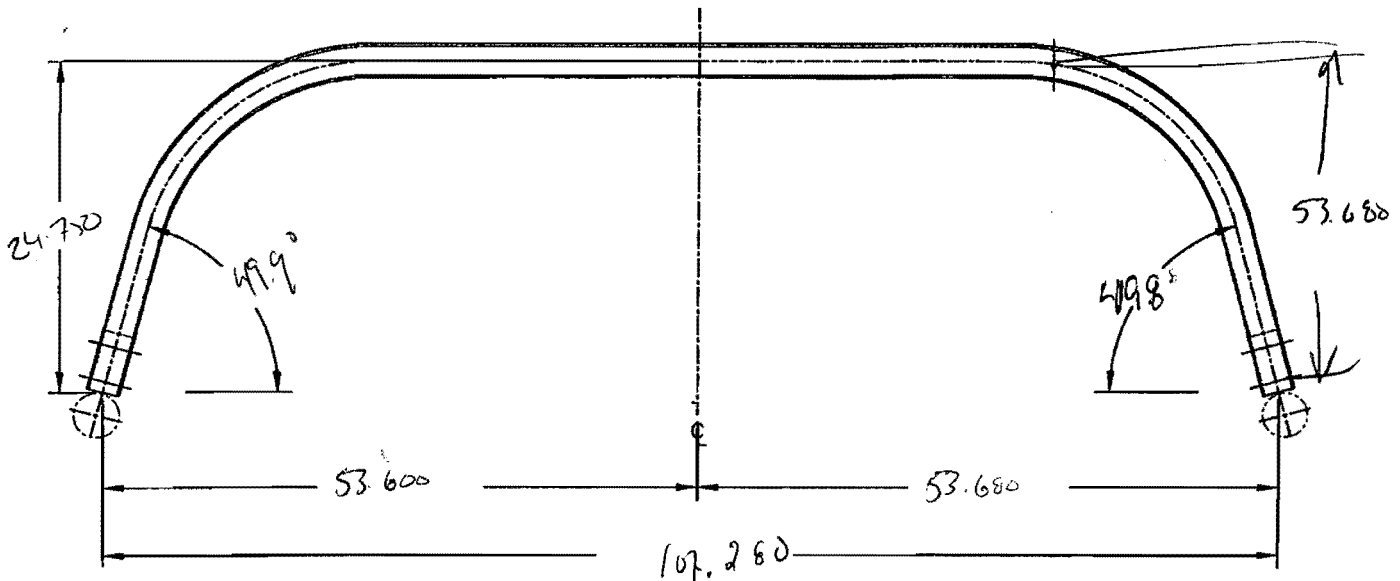
Comments
Tube over tol. on height OK CP 11.05.16

QC15 Inspection	CP
Date	11.05.16

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	
C	10.04.01	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 68613	
Description: Crosstube High Aft (205/212)		Part Number: D212-664-201	
Inspection Dwg: D212-664-241 Rev: D			Page 1 of 1

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	
C	10.04.01	Dwg Rev updated	KJ	

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	4	4	MS21920-28	CLAMP (OR MS21920-30)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)
D212-664-241B = 44.2 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68613*
11-07-18

DEO ATTACHED

RELEASED
2009-10-29
W

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>		
DRAWN	RF		
CHECKED	<i>Q</i>		
MFG. APPR.	<i>DS</i>		
APPROVED	<i>W</i>		
DE APPR.	<i>W</i>		
DATE	09.09.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D212-664-241	REV. D SHEET 1 OF 4
TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
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8 7 6 5 4 3 2 1

12 13 15
D2940-1 SUPPORT
MS21920-28 CLAMP, 2X
D3595-063-530 RUBBER CUSHION, 2X
2 PL

A5-2

A

14.00 (-241)
OR 13.75 (-241B)

D

D212-664-601
BENT TUBE

Q
SYM

D212-664-241/-241B
ASSEMBLY DETAIL

D

u/c 68613

DEO ATTACHED

RELEASED
2009-10-28

12
APPLY MAGNOBOND
BETWEEN D2940-1 AND
CROSSTUBE

D2940-1 SUPPORT, REF

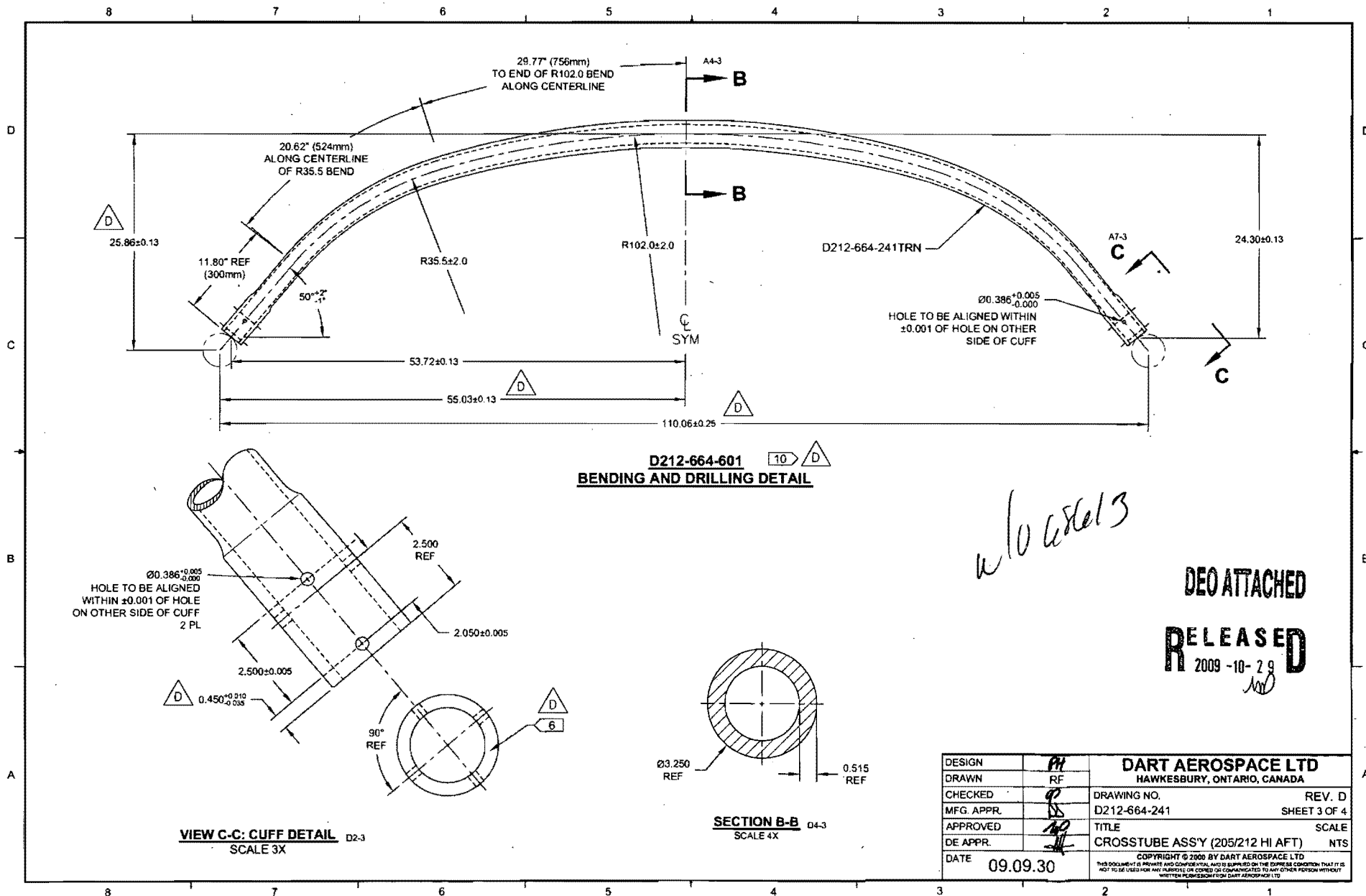
13 15
MS21920-28
CLAMP, REF

D3595-063-530 RUBBER CUSHION
UNDER CLAMP, REF

SECTION A-A D6-2
SCALE 4X

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JS	D212-664-241	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



DRAWING NO. D212-664-241	TITLE CROSSTUBE ASSY (205/212 HI AFT)	REV. D	DART AEROSPACE LTD. ENGINEERING ORDER		D.E.O. NO. D212-664-241-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12			

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

RELEASED
2011-04-18
JH

u/068613



LIQUID PENETRANT TEST REPORT

P. 05609

CLIENT DART AEROSPACE DATE MAY-18-2011 PAGE 1 OF 1
ATTENTION LYNDA LUCILLE CHASTALE/IAN ACUREN JOB NO. 188-11-00128 TIME AM ☐ PM ☐
ADDRESS 1270, ABERDEEN RD PO/NO. 14017
HAWES BURN ON WORK LOCATION AS ADDRESSED
ACCEPTANCE STD. ASTM H17.02-033 REV./DATE 2005
PROJECT WET FLUORESCENT LIQUID PENETRANT INSPECTION ON 4 X "CROSSTUBES"
ITEM(S) EXAMINED - SEE BELOW

OB DESCRIPTION PERFORMED A WET-FRUE L.P.T. ON 100% OF THE EXTERNAL SURFACE
ART NO. 00 4 X "CROSSTUBES" MATERIAL C15 THICKNESS N/A
COPE PERFORMED A WET-FRUE L.P.T. ON 100% OF THE EXTERNAL SURFACE
00 4 X "CROSSTUBES"

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☐ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
AMILY BRAND MAC-100-X BLACK LIGHT S/N 13793 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
ENETRANT ZL-62 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
ENETRANT REMOVER A20 MINIMUM DRY TIME >10 MIN. OTHER
DEVELOPER SKD-53 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE help for
DEVELOPER TYPE ☒ NON-AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☐ METRIC ☐ IMPERIAL

ITEM ID
1. CROSSTUBE W.O. ID 63613 ✓
2. " W.O. ID 63614 ✓
3. " W.O. ID 69333 ✓
4. " W.O. ID 69335 ✓
D212-664-201 AFT
D212-664-201 HFT
D212-664-101 FWD
D212-664-101 FWD
RT 11 05-18
NO RELEVANT INDICATION WAS DETECTED
AS PER APPLICABLE STANDARD

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended to be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibility of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Ian Tiffey SIGNATURE Ian Tiffey DTR # E 44656
TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY:
NAME (PRINT): [Signature] NAME INITIALS
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL 2 SNT LEVEL 3049 CGSB LEVEL 2 SNT LEVEL 3049
CGSB REG. No 3049 CGSB REG. No 3049

